

Date: Thursday, 4/12/2007 9:34:38 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	STEP SPACER
Job Number	31794A	Part Number	D30651
Estimate Number	10375	Drawing Number	D3065 REV. B
P.O. Number	N/A	Project Number	N/A
This Issue	4/12/2007	Type	SMALL /MED FAB
Prsht Rev.	NC	Drawing Revision	B
First Issue	N/A	Material	N/A
Previous Run	31339A	Due Date	5/15/2007
Written By		Qty:	60
Checked & Approved By	<u>CFJ 07.04.12</u>	Um:	Each
Comment	Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF Est:D 06.04.25 Water jet EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S040	2024-T3 .040 sheet
		Comment: Qty.: 0.1300 sf(s)/Unit Total : 7.7994 sf(s) Material: 2024-T3 (QQ-A-250/4) 0.040" thick (M2024T3S.040) Batch: <u>m103321</u> <u>m 07 05 07</u> (60)
2.0	WATER JET	FLOW WATER JET
		Comment: FLOW WATER JET 1-Cut as per Dwg D3065 Dwg Rev: <u>B</u> <u>m 07 05 07</u> (60) Prog Rev: <u>B</u>
3.0	QC2	2-Deburr as required INSPECT PARTS AS THEY COME OFF MACHINE <u>m 07 05 07</u> (60)
4.0	QC8	SECOND CHECK <u>070507</u>
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary. <u>SAD 07/05/07</u> 60

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/06/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 9:34:38 AM
User: Kim Johnston 980

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: STEP SPACER
Job Number: 31794A		Part Number: D30651
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	BRAKE NC	NC BRAKE
Comment: NC BRAKE Bend as per Dwg D3065		SB 07-05/14 (60)
7.0	QC5	INSPECT WORK TO CURRENT STEP
		JULY 07
Comment: INSPECT WORK TO CURRENT STEP		
8.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1		WJ 07-06-08 (60)
9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
Comment: INSPECT CHEMICAL CONVERSION COAT		SB 07/06/08
10.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: GA		2B 07/06/08 (60)
11.0	QC21	FINAL INSPECTION/W/O RELEASE
Comment: FINAL INSPECTION/W/O RELEASE		SB 07/06/11 (60)
Job Completion		
		W 07-06-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31794A
Description: Step Spacer	Part Number:	D3065-1
Inspection Dwg: D3065 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

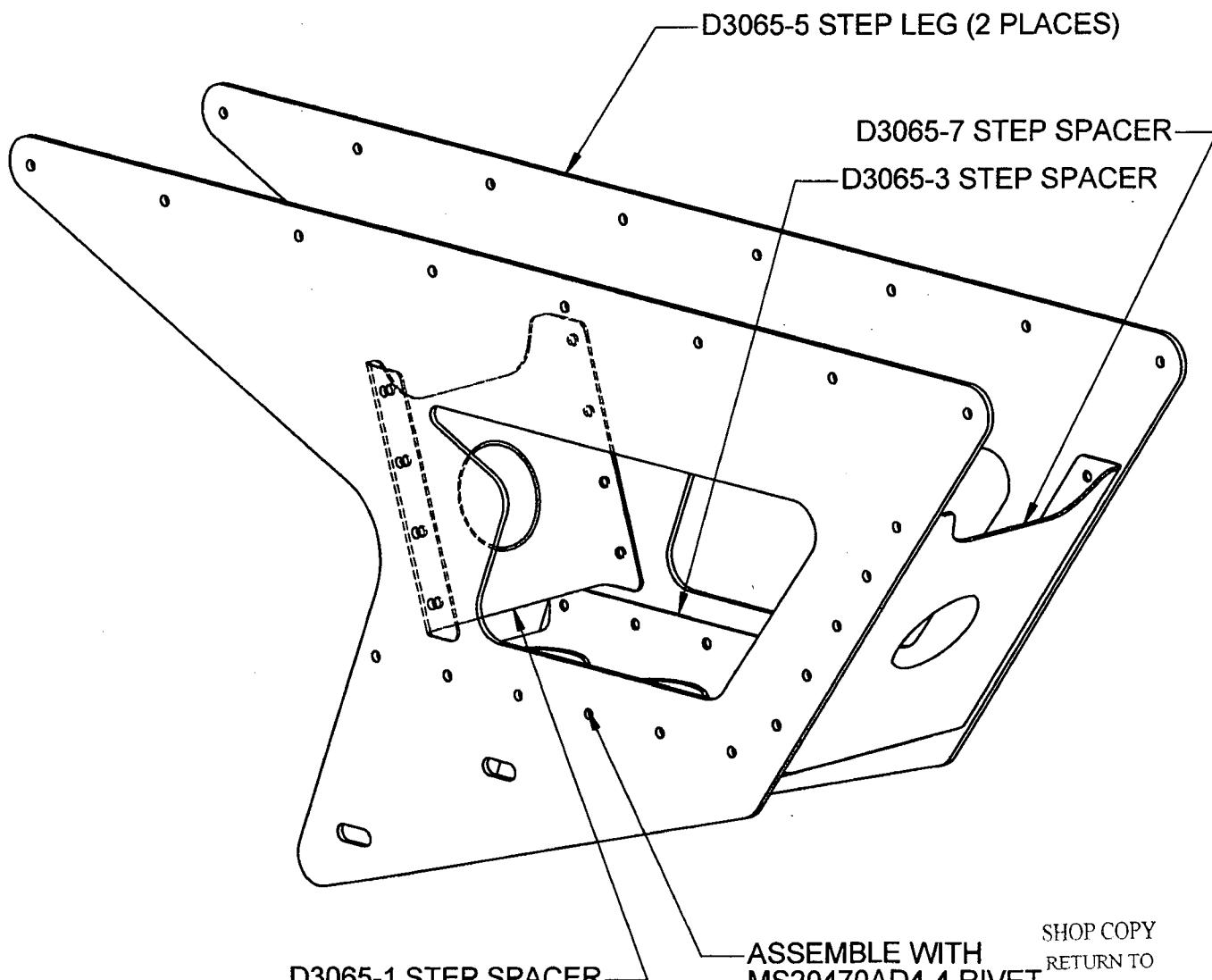
X First Article Prototype

Measured by:	<i>M. M.</i>	Audited by:	<i>/</i>	Prototype Approval:	<i>N/A</i>
Date:	07/05/07	Date:	07/05/07	Date:	<i>/</i>

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D3065-041	KJ/RF	
B	06.06.23	Dwg Rev. changed	KJ/JLM	
C	07.02.07	Dimension 0.040 added	KJ/JLM	

DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065
DATE 06.05.23		REV. B SHEET 1 OF 5 TITLE STEP LEG ASSEMBLY SCALE 1:2

RELEASED06.06.20 *[Signature]*

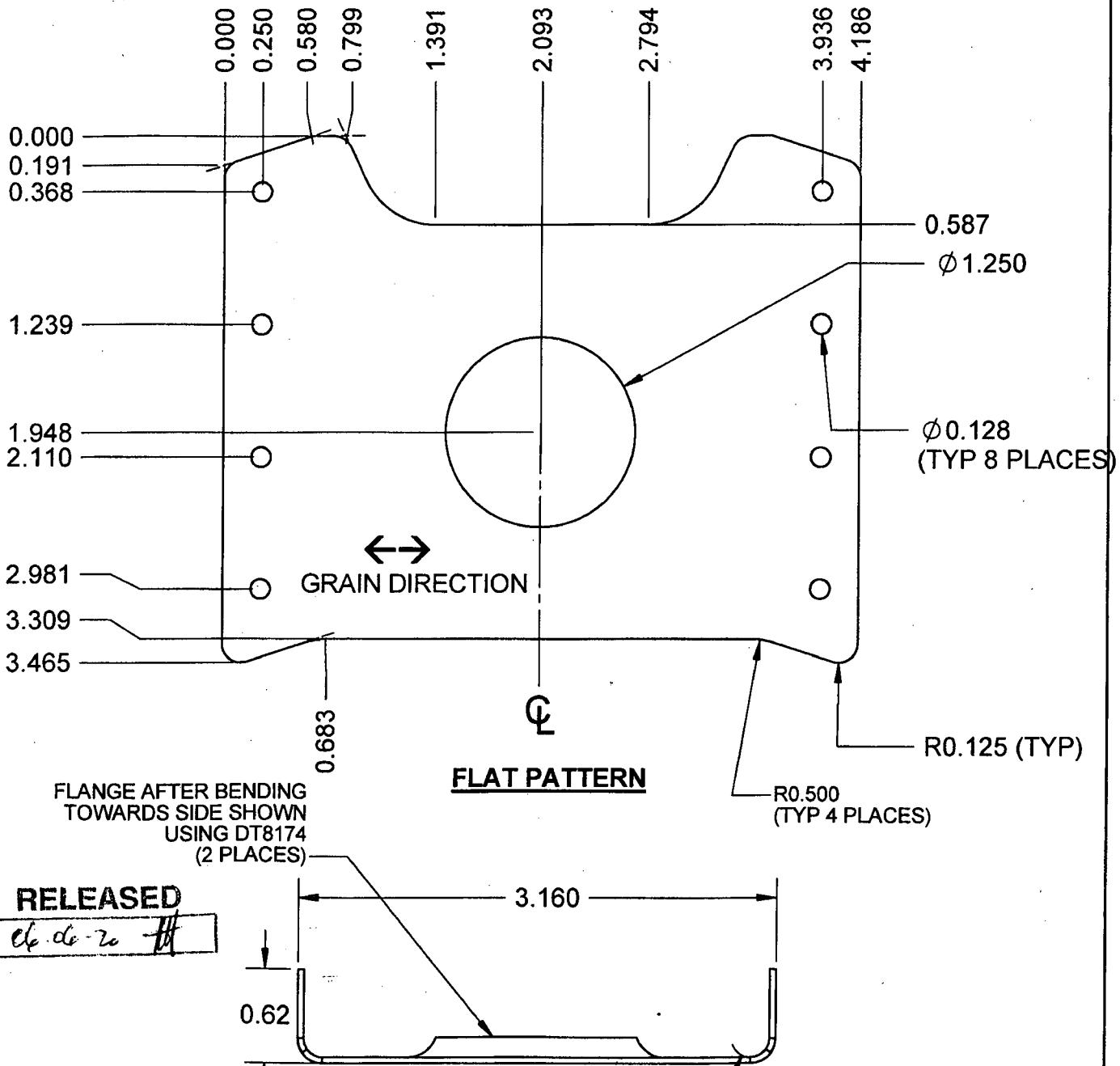
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NO. 31794A

D3065-041 STEP LEG ASSEMBLY**COPYRIGHT © 2002 BY DART AEROSPACE LTD.**

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CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. D3065	REV. B SHEET 2 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY	SCALE 1:1	

**D3065-1 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

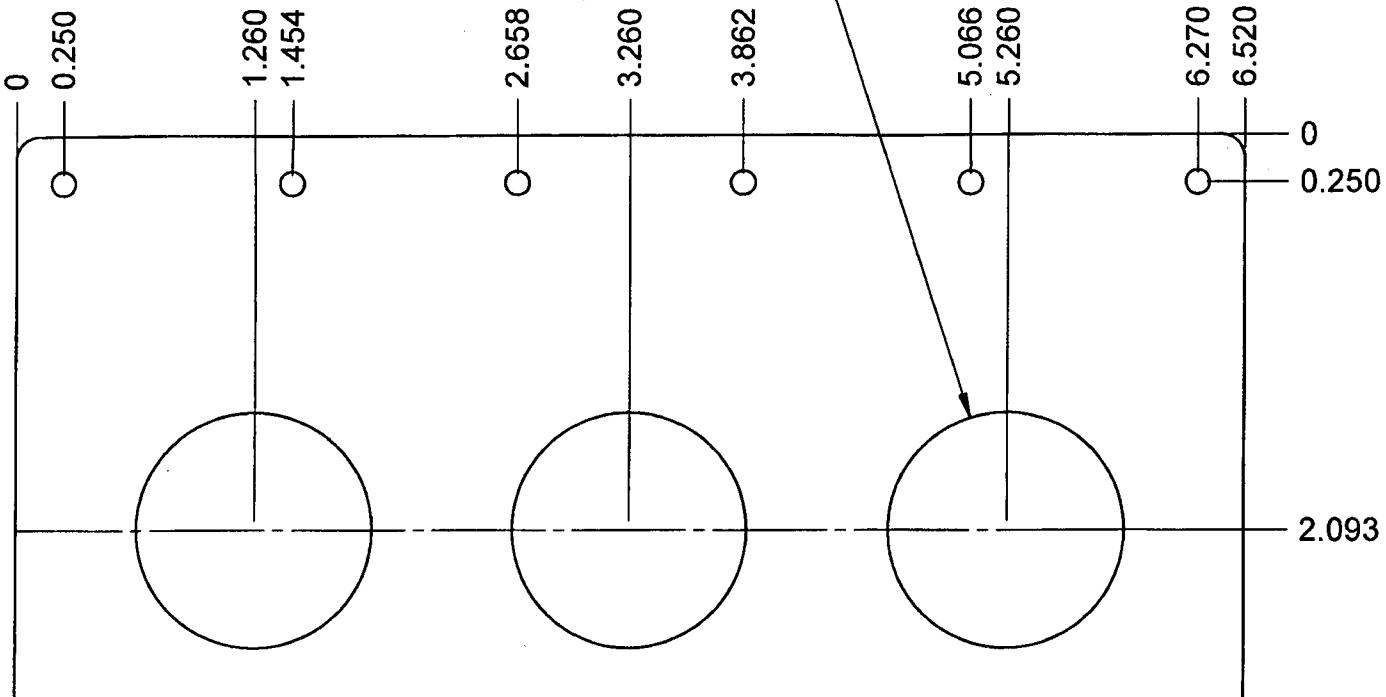
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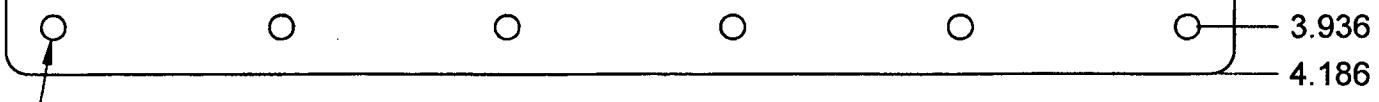
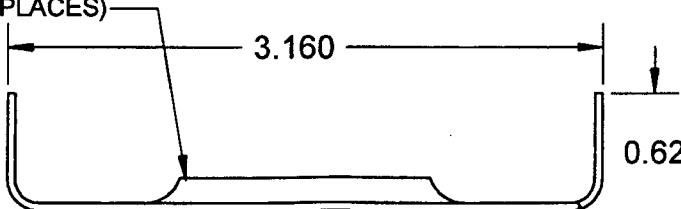
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CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. D3065
DATE 06.05.23	TITLE STEP LEG ASSEMBLY	REV. B SHEET 3 OF 5 SCALE 1:1

 $\phi 1.250$ (TYP, 3 PLACES)**FLAT PATTERN**

↔ GRAIN DIRECTION

FLANGE AFTER TOWARDS SIDE
SHOWN USING DT8174 (3 PLACES) $\phi 0.129$ (TYP, 12 PLACES)**RELEASED***do do 20 - MM***BEND DETAIL**

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NO. *31794A*

D3065-3 STEP SPACER

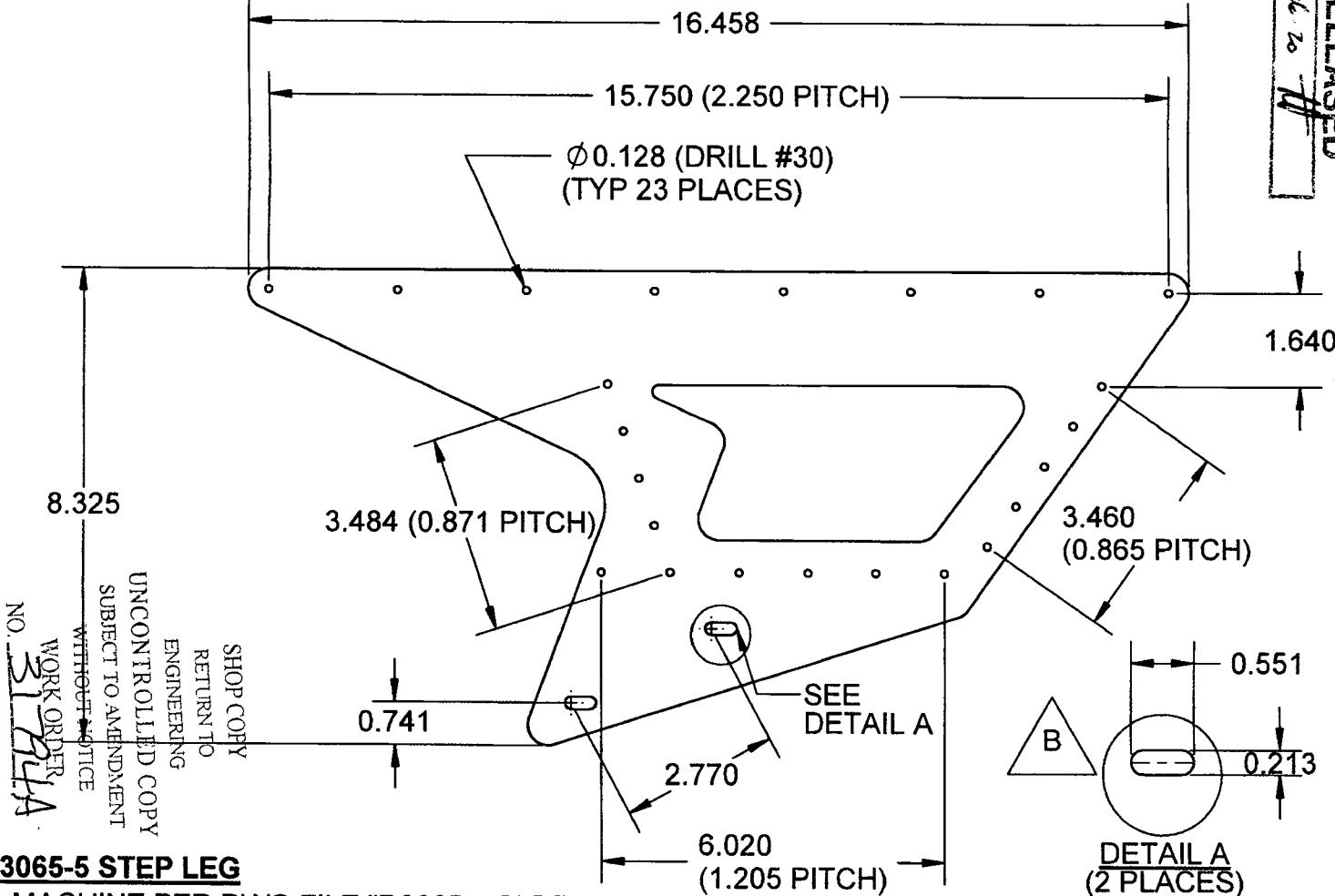
- 1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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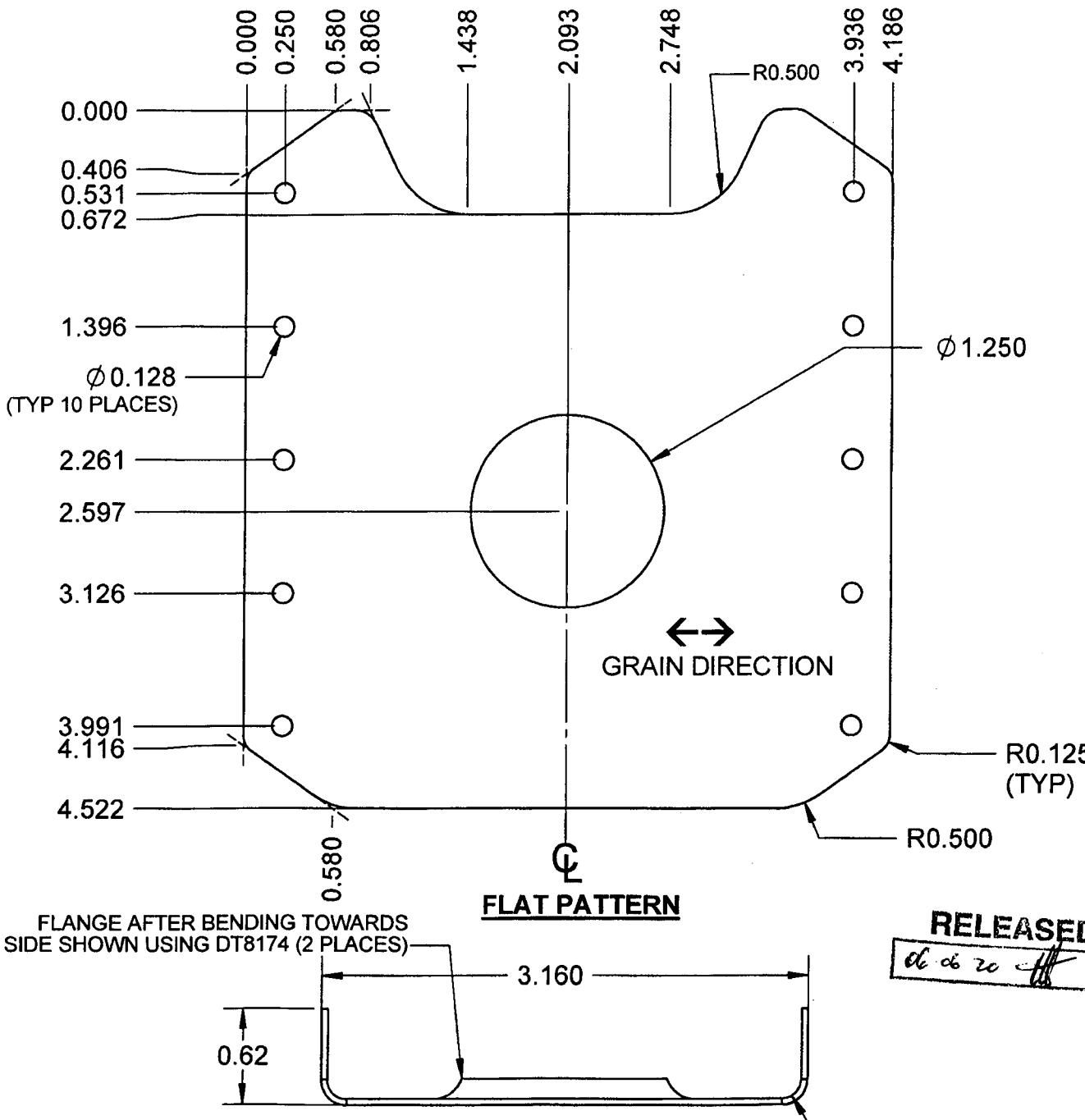
DESIGN <i>1P</i>	DRAWN BY <i>C.B.</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>P/H</i>	APPROVED <i>J.H.</i>	DRAWING NO. <i>D3065</i>
DATE <i>06.05.23</i>	TITLE <i>STEP LEG ASSEMBLY</i>	REV. B SHEET 4 OF 5 SCALE <i>1:3</i>

RELEASED
06.06.20**D3065-5 STEP LEG**

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)
OR
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
PH	MM	D3065	SHEET 5 OF 5
DATE	06.05.23	TITLE	SCALE 1:1

**D3065-7 STEP SPACER**

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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